

Plw MAR 14 2018

Ship April 5



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D205-633-023
Job Sheet 174227



Part No: D205-633-023

Job Qty: 2 ea

Part Name: Heli-Access-Step™ LH - 31" Extended Height Gear, Simplex Tank Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/13/18

Job Tracking No:

Due Date: 4/5/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C SHEET 17 IPP Rev:A new issue Rev B dwg 07-11-19 DD verified by:EC lpp RevB 11.07.26 per
NCR 11-628 EC verified by:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		4/5/18	0.00	0.00	Start Up Stores/Pkg-1		MAR 28 2018
110	Packaging	2 pcs		4/5/18	0.00	0.00	Packaging1-2		MAR 28 2018
120	QC	2 pcs		4/5/18	0.00	0.00	QC4		
125	DC	2 pcs		4/5/18	0.00	0.00	DC		
130	Packaging	2 pcs		4/5/18	0.00	0.00	Packaging3-1		
140	QC21-FG	2 Ea		4/5/18	0.00	0.00	QC21		MAR 20 2018

Part Op 125 - Photocopy bluefile & type labels per PPP D205-633-023 CHG001
Descriptions: 130 - Identify and pack for shipping as per PPP D205-633-023

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4-12A	Bolt	2 Ea (1 ea)	90-Start up Operation	5014151
AN4-14A	Bolt	2 Ea (1 ea)	90-Start up Operation	5027723
AN4-5A	Bolt	2 Ea (1 ea)	90-Start up Operation	5027725
AN4-6A	Bolt	6 Ea (3 ea)	90-Start up Operation	5044186
AN4-7A	Bolt	2 Ea (1 ea)	90-Start up Operation	FM137820.80
AN44-7A	Eyebolt	2 Ea (1 ea)	90-Start up Operation	5038781
AN5-14A	Bolt	2 Ea (1 ea)	90-Start up Operation	FM137699X1
D2022-101	Spacer	8 Ea (4 ea)	90-Start up Operation	5045071
D2022-103	Spacer	4 Ea (2 ea)	90-Start up Operation	5045077
D2562-013	Strut 26.63"	2 Ea (1 ea)	90-Start up Operation	2053719
D2563	Step Weldment Assembly	2 Ea (1 ea)	90-Start up Operation	504057
D2565-201	Strut	2 Ea (1 ea)	90-Start up Operation	5009680
D2565-203	Strut	2 Ea (1 ea)	90-Start up Operation	5009714
D2565-205	Strut	2 Ea (1 ea)	90-Start up Operation	5009804
D2565-207	Strut	2 Ea (1 ea)	90-Start up Operation	5009465
D2565-209	Strut	2 Ea (1 ea)	90-Start up Operation	5009482
D2565-211	Strut	2 Ea (1 ea)	90-Start up Operation	5008513
D3437-043	Aft Strut Assembly	2 Ea (1 ea)	90-Start up Operation	5011844
MS21042L4	Nut	14 Ea (7 ea)	90-Start up Operation	5045901
MS21042L5	Nut	4 Ea (2 ea)	90-Start up Operation	5016880
NAS1149D0463J	Washer	28 Ea (14 ea)	90-Start up Operation	5045845
NAS1149D0563J	Washer	6 Ea (3 ea)	90-Start up Operation	5025743

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging Supplier ☐ Engineering Quality ☐ Other ☐																																																																																																																											
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																																																																																																																									
Description Container No: S055868 Part: D205-633-023 Job No: 174227 Serial No/Batch: S055868 Revision: _____ Inspector: _____ Date: 03/28/18																																																																																																																													
Root Cause <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:15%;">Environment</td> <td style="width:5%;">☐</td> <td style="width:15%;">No Re-verifica</td> <td style="width:5%;">☐</td> <td style="width:15%;"></td> <td style="width:5%;"></td> <td style="width:15%;"></td> <td style="width:5%;"></td> <td style="width:15%;"></td> <td style="width:5%;"></td> </tr> <tr> <td>Design</td> <td>☐</td> <td>Operator</td> <td>☐</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Doc/Data</td> <td>☐</td> <td>Offset/Setup</td> <td>☐</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Equip/Tooling</td> <td>☐</td> <td>Supplier</td> <td>☐</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Handling/Pre</td> <td>☐</td> <td>Training</td> <td>☐</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Material</td> <td>☐</td> <td>Use for Testing</td> <td>☐</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Internal Transport</td> <td>☐</td> <td>Poor Information</td> <td>☐</td> <td>Crushing</td> <td>☐</td> <td>Contamination</td> <td>☐</td> <td>Out of Sequence</td> <td>☐</td> </tr> <tr> <td>Tribal Knowledge</td> <td>☐</td> <td>Rushing</td> <td>☐</td> <td>Heat Treat</td> <td>☐</td> <td>Countersink</td> <td>☐</td> <td>Off-set</td> <td>☐</td> </tr> <tr> <td>LOA</td> <td>☐</td> <td>Product Improvement</td> <td>☐</td> <td>Wave/Twist in Tube</td> <td>☐</td> <td>Cut Too Short</td> <td>☐</td> <td>Mislabeled</td> <td>☐</td> </tr> <tr> <td>Substation</td> <td>☐</td> <td>Process Improvement</td> <td>☐</td> <td>Marks/Chatter</td> <td>☐</td> <td>Instructions Incomplete/Unclear</td> <td>☐</td> <td>Fit/Function</td> <td>☐</td> </tr> <tr> <td>Past Expiry Date</td> <td>☐</td> <td>Manufacturing Process</td> <td>☐</td> <td></td> <td></td> <td>Drill Holes</td> <td>☐</td> <td>Misaligned/off center</td> <td>☐</td> </tr> <tr> <td>Misidentified</td> <td>☐</td> <td>Past Due</td> <td>☐</td> <td colspan="6" style="text-align: center;">OTHER : _____</td> </tr> </table>				Environment	☐	No Re-verifica	☐							Design	☐	Operator	☐							Doc/Data	☐	Offset/Setup	☐							Equip/Tooling	☐	Supplier	☐							Handling/Pre	☐	Training	☐							Material	☐	Use for Testing	☐							Internal Transport	☐	Poor Information	☐	Crushing	☐	Contamination	☐	Out of Sequence	☐	Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Countersink	☐	Off-set	☐	LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Cut Too Short	☐	Mislabeled	☐	Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Past Expiry Date	☐	Manufacturing Process	☐			Drill Holes	☐	Misaligned/off center	☐	Misidentified	☐	Past Due	☐	OTHER : _____						Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐ Pulled ☐	
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Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN4-12A	2	167	0
	AN4-14A	2	409	0
	AN4-5A	2	100	0
	AN4-6A	6	741	0
	AN4-7A	2	76	0
	AN44-7A	2	9	0
	AN5-14A	2	7	0
	D2022-101	8	69	0
	D2022-103	4	39	0
	D2562-013	2	0	0
	D2563	2	4	0
	D2565-201	2	2	0
	D2565-203	2	2	0
	D2565-205	2	2	0
	D2565-207	2	3	0
	D2565-209	2	3	0
	D2565-211	2	2	0
	D3437-043	2	2	0
	MS21042L4	14	3,343	0
	MS21042L5	4	805	0
	NAS1149D0463J	28	4,436	0
	NAS1149D0563J	6	2,202	0
Part Specifications				
Specifications could not be found.				

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

5.2 D205-633-021/-022/-023/-024/-025/-026 Hell-Access Step
(Simplex Model 304 Fire Attack Tank Compatible)

QTY -021	QTY -022	QTY -023	QTY -024	QTY -025	QTY -026	Part Number	Description
X						D205-633-021	Hell-Access-Step™ (LH), High Gear
	X					D205-633-022	Hell-Access-Step™ (RH), High Gear
		X				D205-633-023	Hell-Access-Step™ (LH), Extended High Gear (31")
			X			D205-633-024	Hell-Access-Step™ (RH), Extended High Gear (31")
				X		D205-633-025	Hell-Access-Step™ (LH), Extended High Gear (39")
					X	D205-633-026	Hell-Access-Step™ (RH), Extended High Gear (39")
4	4	4	4	4	4	D2022-101	SPACER
2	2	2	2	2	2	D2022-103	SPACER
				1	1	D2562-005	STRUT
1	1					D2562-011	STRUT
		1	1			D2562-013	STRUT
1		1		1		D2563	WELDMENT ASSEMBLY
1	1					D2565-101	STRUT
1	1					D2565-103	STRUT
1	1					D2565-105	STRUT
1	1					D2565-107	STRUT
1	1					D2565-109	STRUT
*1	*1					D2565-111	STRUT
		1	1			D2565-201	STRUT
		1	1			D2565-203	STRUT
		1	1			D2565-205	STRUT
		1	1			D2565-207	STRUT
		1	1			D2565-209	STRUT
		*1	*1			D2565-211	STRUT
				1	1	D2565-301	STRUT
				1	1	D2565-303	STRUT
				1	1	D2565-305	STRUT
				1	1	D2565-307	STRUT
				1	1	D2565-309	STRUT
				*1	*1	D3165-1	SUPPORT ARM
1	1					D3437-041	AFT STRUT ASSEMBLY
		1	1			D3437-043	AFT STRUT ASSEMBLY
				1	1	D3437-045	AFT STRUT ASSEMBLY
	1		1		1	D3438-042	WELDMENT ASSEMBLY
1	1	1	1	1	1	AN4-5A	BOLT
4	4	3	3	3	3	AN4-6A	BOLT
1	1	1	1	1	1	AN4-7A	BOLT
1	1					AN4-11A	BOLT
		1	1	1	1	AN4-12A	BOLT
1	1	1	1	1	1	AN4-14A	BOLT
1	1	1	1	1	1	AN44-7A	EYEBOLT
1	1	1	1	1	1	AN5-14A	BOLT
16	16	14	14	14	14	AN960JD416	WASHER
3	3	3	3	3	3	AN960JD516	WASHER
8	8	7	7	7	7	MS21042L4	NUT (or MS21042-4)
2	2	2	2	2	2	MS21042L5	NUT (or MS21042-5)

* ONLY INSTALLED IF TANK IS REMOVED